



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74733

Wednesday, October 05, 2011 2:35:12 PM



Page 2

Item ID: D3506-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 10/5/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		<i>36-bul</i>	<i>w1.0103</i>	<i>21</i>			
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>B.A</i>	<i>11/11/05</i>	<i>21</i>	<i>φ</i>		
150  Small Fab Small Fab Small Fab	Small Fab  Memo C'sink as per Dwg D3506(On Flat side)	0.00  0.00							<i>11/11/08</i> <i>(21)</i>

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**Work Order ID 74733**

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Item ID: D3506-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/5/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				counts (21)			
170  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				21	11-11-8		
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				21	11-11-08		

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**Work Order ID 74733**

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Item ID: D3506-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/5/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: B3

0.00



Packaging

Memo

0.00

Packaging

11/11/09 [Signature] (210)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/09 [Signature]  
mf 11-11-09

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, October 05, 2011 2:35:17 PM

Page 1

Work Order ID: 74733

Parent Item: D3506-1

Parent Item Name: Doubler



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-05-31 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100 		Purchased	No			110	sf	108.4000	0.0078	0.098526		S	
6061-T6 .100 Sheet												RB11-10-21	

Location

Loc Qty

Loc Code

MAT021

108.4

102201

1

118072

22.9

118523

84.5

118523

22

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 74733
Description: Doubler		Part Number: D3506-1
Inspection Dwg: D3506	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	X		V 1B02	
Ø0.404	+0.006/-0.001	.405	X		V	
0.750	+/-0.010	.752	X		V	
1.500	+/-0.010	1.504	X		V	
0.375	+/-0.010	.374	X		V	
0.750	+/-0.010	.749	X		V	
0.250	+/-0.010	.252	X		V	
0.098	+/-0.010	.098	X		V	

Measured by: B
Date: 11-10-21

Audited by: M.A
Date: 11/11/25

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.09	New Issue	KJ/JLM	B

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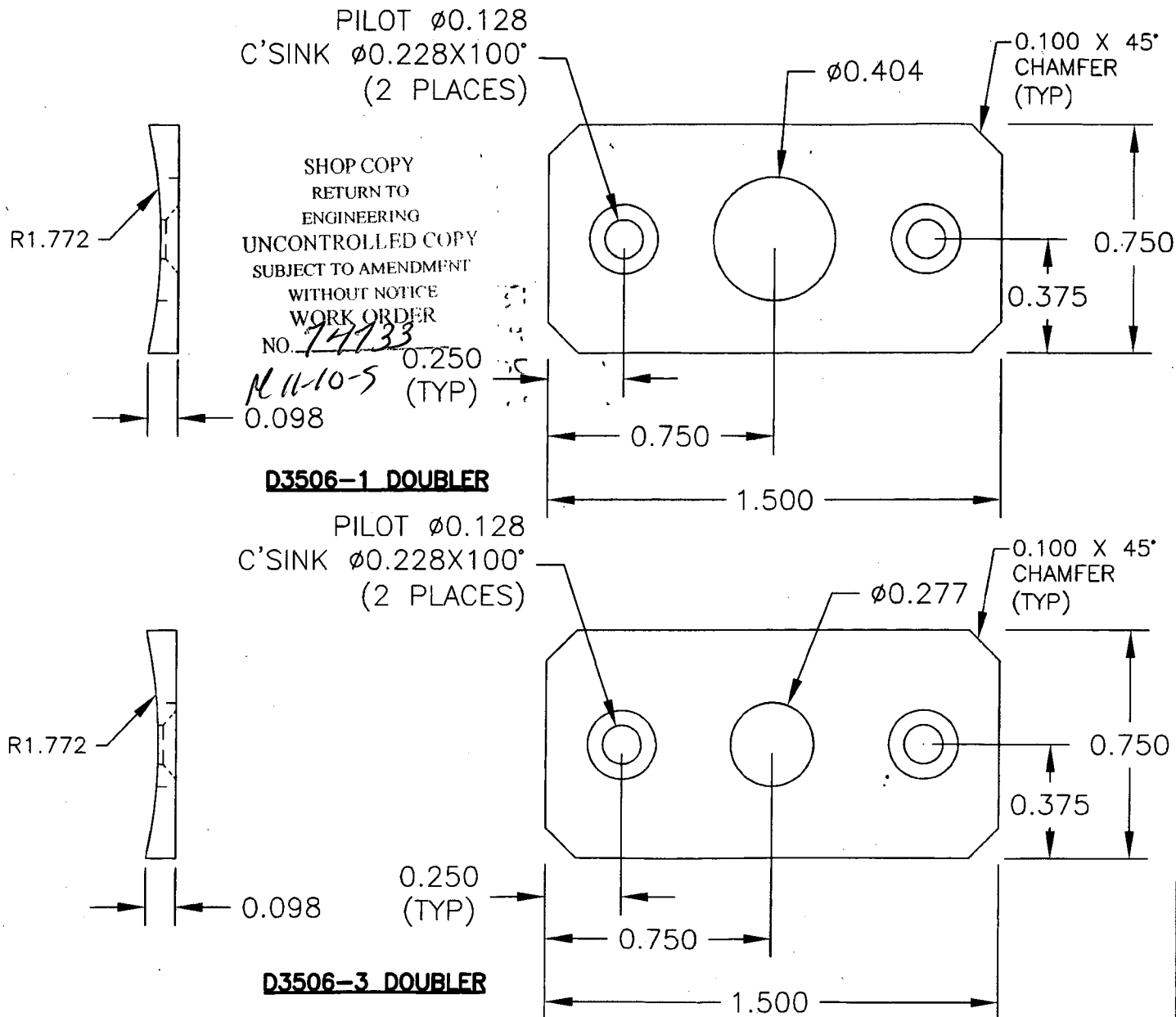
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN 9H	DRAWN BY 9H	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED JH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	



**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**  
06.10.02 PM  
per E/W #361

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W/O:		WORK ORDER CHANGES					
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1							

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